

Work Order ID 78955

78955

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January-17-12 2:51:39 PM

Item ID: D2939-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 17/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2939	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00 FK/D.A. 12/03/15 6 φ
100
 HAAS 1
 HAAS CNC vertical machine #1

Memo

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110 CONVENTIONAL MILLING MACHINE 0.00 FK/D.A. 12/03/15 6 φ
110
 Mill Conv
 Conventional Milling Machine

Memo

Machine Keyway and inspect per attached dimension sheet

120 QC1- Inspect dimensions to dimension sheet 0.00 FK/D.A. 12/03/15 6 φ
120
 QC
 Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12/03/18		(6)			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							2/6- 12-3-19
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 2h10 FINISH TIME: 2h40	0.00 0.00				6	8	(2P) 12/03/20	OVEN TEMPERATURE: 320°F m120222

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00

160

QC Memo 0.00

Quality Control

6X0 M/L 12/3/20

170 Identify as per dwg & Stock Location: Y28A 0.00

170

Packaging Memo 0.00

Packaging

12/3/21 sl @

180 QC21- Final Inspection - Work Order Release 0.00

180

QC Memo 0.00

Quality Control

12/3/21 J

*MF
12-03-21*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January-17-12 2:51:43 PM

Page 1

Work Order ID: 78955

78955

Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001

Manufactured

No

100

Each

14.0000

1

6

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

14

69677

2

73774

11

76836

1

79586

6

K.K. 12/03/13

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78955
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.118	.118	.116	.117	.116
B	0.100	0.140		.118	.118	.116	.116	.116
C	0.100	0.140		.116	.116	.115	.115	.116
D	0.210	0.230		.222	.222	.222	.222	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.260	.260	.260	.260	.260
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.237	.237	.237	.237	.237
N	0.100	0.140		.121	.120	.121	.121	.121
O	0.540	0.560		0.550	0.550	0.550	0.550	0.549
P	0.490	0.510		0.498	0.498	0.499	0.499	0.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.252	.252	.253	.252	.253
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.2595	1.259	1.259	1.2585	1.259
Y	1.565	1.585		1.573	1.573	1.573	1.573	1.573
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: FK / BA	Date: 12/03/15
Audited by: [Signature]	Date: 12/03/18
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

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DART AEROSPACE LTD		Work Order: 78955
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939	Rev: C	DSK: Rev: Page 1 of 1

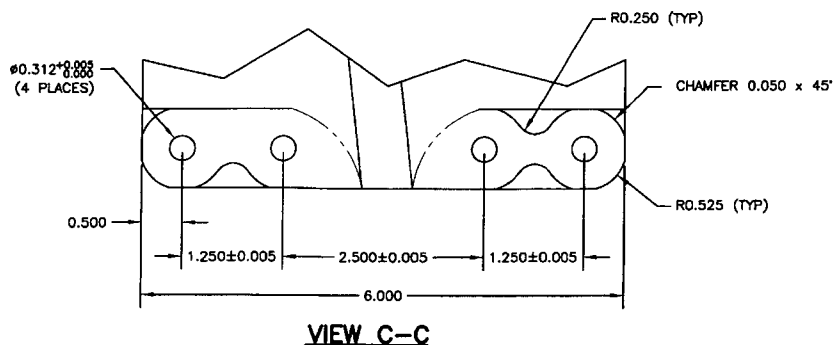
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	2	3	4	5
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B	0.100	0.140		.116				
C	0.100	0.140		.117				
D	0.210	0.230		.222				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
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H	0.510	0.515		.512				
I	1.572	1.582		1.577				
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U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		.316				
X	1.250	1.270		1.259				
Y	1.565	1.585		1.573				
Z	0.178	0.198		0.188				
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: FK	Date: 12/03/14
Audited by: JL	Date: 12/03/18
Prototype Approval: N/A	Date: N/A

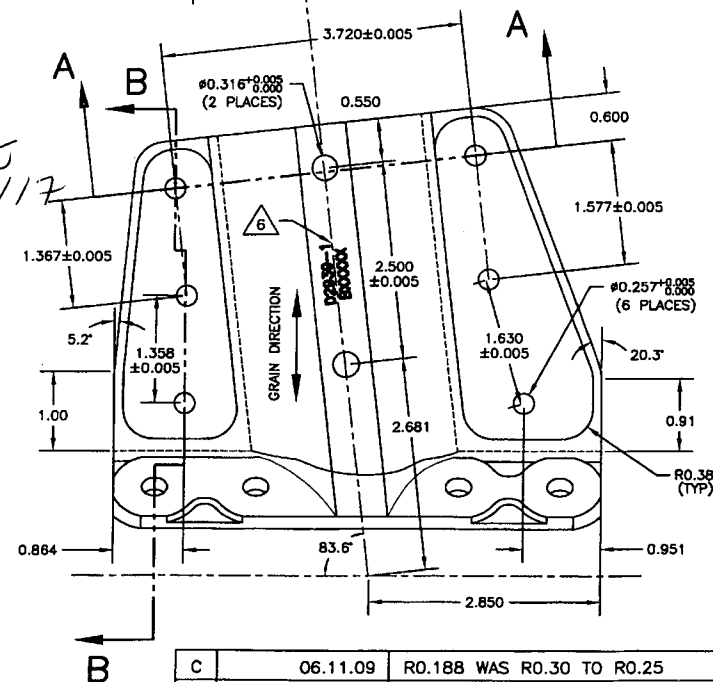
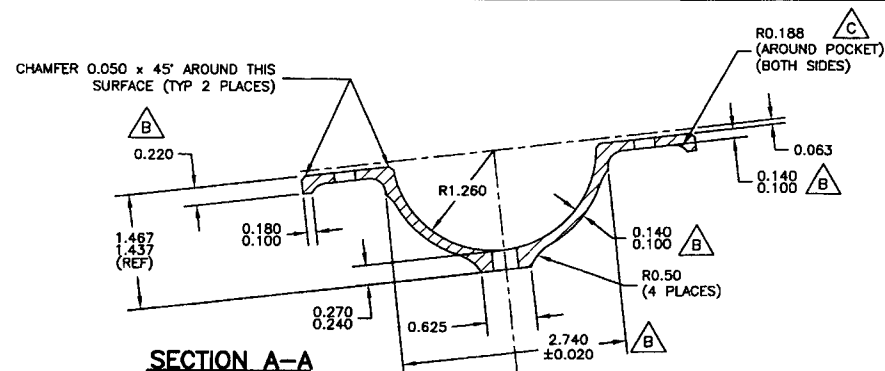
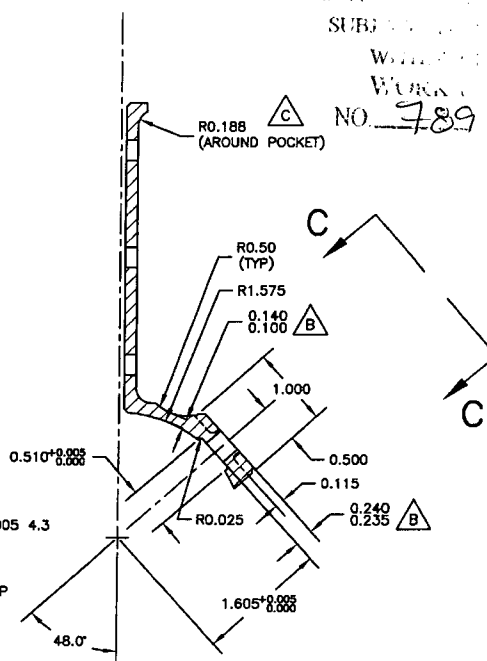
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D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC.
CHECKED	PH	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE
REV. C		SHEET 1 OF 1
SCALE		2:3

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 DART AEROSPACE USA, INC.

07.02.12

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